

**Work Order ID 73407**

Wednesday, August 31, 2011 3:06:13 PM



Page 1

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan: CL

Date: 1/10/2011

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
100	HAAS CNC VERTICAL MACHINING #1	0.00	CL	B.A	11/10/28	20	0		

HAAS 1



Memo

0.00

HAAS CNC vertical machine #1

Program Batch No. 373407 Double check by: CL 1-Machine Step No 1 per Folio FA641 and inspect per attached Dimension Sheets 2-Machine Step No 2 per Folio FA641 and inspect per attached Dimension Sheets 3-Machine Step No 3 per Folio FA641 and inspect p

110



QC2- Inspect parts off machine FAI/FAIB

0.00

  
11/10/28

20

20

Quality Control

Memo

0.00

120



QC8- Inspect parts - second check

0.00

  
11/10/30

20

Quality Control

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73407**

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Wednesday, August 31, 2011 3:06:13 PM

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130



Chemical Conversion Coat per QSI005 4.1

0.00

20 BL 11-10-31.

HandFinish

Memo

0.00

Hand Finishing

140



White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

20 X 8 m-f 11/10/31

Powdercoat

Memo

11:45 0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

 FINISH TIME:

3230F

1275

150



QC3- Inspect Part Finish

0.00

20 BL 11-10-31.

QC

Memo

0.00

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 73407**

Wednesday, August 31, 2011 3:06:13 PM



Page 3

Item ID: D3500-1

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 8/31/2011 Start Qty: 20.00



Cust Item ID:

Required Date: 9/21/2011 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
Description

160

Identify as per dwg & Stock Location: 427Set Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

0.00

11/01/31 / (22)

Packaging

Memo

0.00

Packaging

170



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

11/11/01 / (22)

MF  
11/11/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_  
 Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

# Picklist Print

Wednesday, August 31, 2011 3:06:11 PM

Page 1

Work Order ID: 73407



Parent Item: D3500-1



Parent Item Name: Saddle

Start Date: 8/31/2011

Required Date: 9/21/2011

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 06-06-15 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D6102-013		Manufactured	No			100	Each	36.0000	1	20			

Saddle Billet



Location	Loc Qty	Loc Code
MAT043	36	
59467	3	
60713	8	
61300	1	
70674	24	

B73492

20.0

8.11/10/28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	73407
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.483	0.490		.486	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		0.383	.382	.382	.382		
F	0.490	0.510		0.497	.500	.497	.497		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.584	1.590	1.587	1.587		
J	0.240	0.260		0.249	.241	.244	.245		
K	0.490	0.510		0.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		0.318	.317	.317	.317		
N	0.256	0.262		0.258	.260	.260	.260		
O	6.500	6.520		6.510	6.570	6.570	6.572		
P	5.990	6.010		5.999	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		0.549	.549	.549	.548		
V	0.793	0.803		0.798	.798	.798	.798		
W	R.240	R.260		0.250	.250	.250	.250		
X	0.040	0.060		0.047	.048	.048	.045		
Y	0.100	0.120		0.110	.110	.110	.110		
AA	R1.125	R1.145		1.130	1.135	1.132	1.131		
AB	R.490	R.510		0.500	.500	.500	.500		
AC	0.615	0.635		0.625	.635	.635	.635		
AD	0.240	0.260		0.254	.247	.249	.250		
AE	1.810	1.830		1.820	1.818	1.818	1.818		
AF	0.240	0.260		0.248	.247	.247	.245		
AG	0.140	0.160		0.151	.150	.150	.149		
AH	0.140	0.160		0.160	.143	.147	.147		
AI	0.140	0.160		0.160	.154	.156	.155		
Accept/Reject									

Measured by:	b.a / cmk	Audited by:	
Date:	11/10/28 / 11/10/29	Date:	11/10/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	

DART AEROSPACE LTD				Work Order:	73407
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	15	16	17	18	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.499	.499	.499	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.586	1.586		
J	0.240	0.260		.243	.245	.244	.244		
K	0.490	0.510		.499	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.512	6.512	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.549	.549	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.050	.046	.045	.048		
Y	0.100	0.120		.112	.110	.112	.111		
AA	R1.125	R1.145		1.133	1.133	1.132	1.132		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.251	.250	.250		
AE	1.810	1.830		1.819	1.819	1.818	1.818		
AF	0.240	0.260		.245	.246	.245	.245		
AG	0.140	0.160		.149	.149	.149	.149		
AH	0.140	0.160		.158	.147	.147	.147		
AI	0.140	0.160		.155	.153	.154	.152		
Accept/Reject									

Measured by:	<u>KJ</u>	Audited by:	<u>KJ</u>
Date:	11/10/29	Date:	11/10/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AK

DART AEROSPACE LTD				Work Order:	73407
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	.19	.10	.11	.12	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.500	.500	.499		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.587	1.586	1.588		
J	0.240	0.260		.244	.244	.244	.244		
K	0.490	0.510		.500	.500	.500	.499		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.511	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.547	.548	.549	.548		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.046	.046	.045		
Y	0.100	0.120		.110	.110	.111	.110		
AA	R1.125	R1.145		1.132	1.133	1.131	1.132		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.810	1.830		1.818	1.818	1.818	1.818		
AF	0.240	0.260		.245	.246	.244	.245		
AG	0.140	0.160		.149	.149	.149	.149		
AH	0.140	0.160		.147	.147	.147	.147		
AI	0.140	0.160		.154	.155	.154	.154		

Accept/Reject

Measured by:	<i>mk</i>	Audited by:	<i>mk</i>
Date:	11/01/29	Date:	11/01/30

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>mk</i>

DART AEROSPACE LTD				Work Order:	73407
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.499	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.586	1.586	1.587	1.587		
J	0.240	0.260		.245	.244	.244	.244		
K	0.490	0.510		.499	.499	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.510	6.510	6.510	6.510		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.548	.548	.548	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.045	.048	.045		
Y	0.100	0.120		.108	.110	.110	.110		
AA	R1.125	R1.145		1.131	1.132	1.134	1.133		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.257	.250	.250	.250		
AE	1.810	1.830		1.817	1.818	1.819	1.818		
AF	0.240	0.260		.246	.245	.241	.241		
AG	0.140	0.160		.149	.149	.149	.149		
AH	0.140	0.160		.147	.147	.148	.148		
AI	0.140	0.160		.155	.155	.155	.152		
Accept/Reject									

Measured by:	<i>cmf</i>	Audited by:	<i>cmf</i>
Date:	11/10/130	Date:	11/10/130

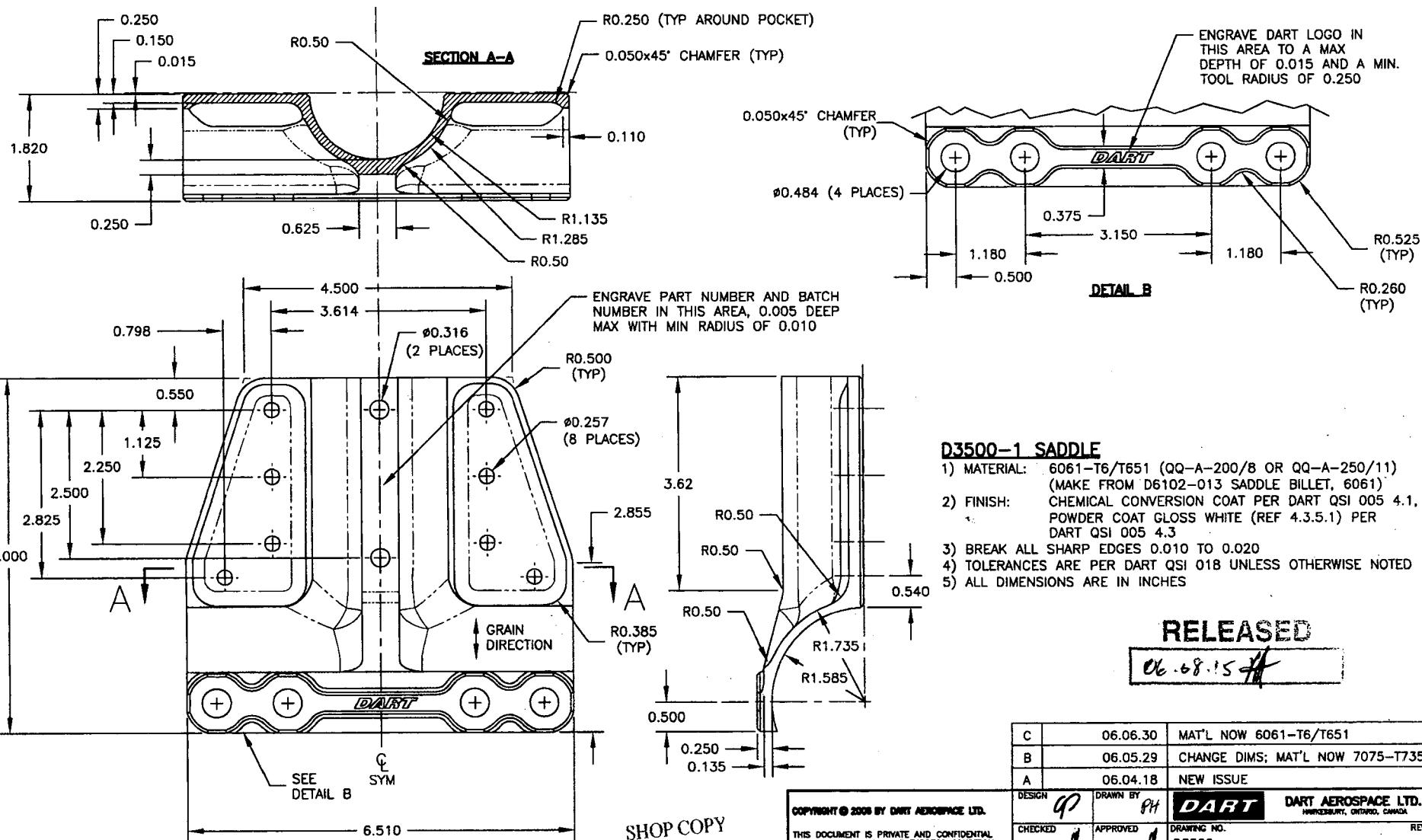
Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	<i>AK</i>

DART AEROSPACE LTD				Work Order:	73407
Description: Saddle				Part Number:	D3500-1
Inspection Dwg: D3500 Rev: C				Page 1 of 1	

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	.117	.118	.119	.120	By	Date
A	0.483	0.490		.487	.487	.487	.487		
B	1.175	1.185		1.180	1.180	1.180	1.180		
C	3.145	3.155		3.150	3.150	3.150	3.150		
D	1.175	1.185		1.180	1.180	1.180	1.180		
E	0.365	0.385		.382	.382	.382	.382		
F	0.490	0.510		.500	.500	.500	.500		
H									
(Note: Dimension I is 0.015" over flange)									
I	R1.575	R1.595		1.587	1.588	1.586	1.586		
J	0.240	0.260		.244	.244	.244	.244		
K	0.490	0.510		.500	.500	.500	.500		
L	3.590	3.650		3.620	3.620	3.620	3.620		
M	0.315	0.322		.317	.317	.317	.317		
N	0.256	0.262		.260	.260	.260	.260		
O	6.500	6.520		6.570	6.570	6.570	6.570		
P	5.990	6.010		6.000	6.000	6.000	6.000		
Q	2.820	2.830		2.825	2.825	2.825	2.825		
R	2.495	2.505		2.500	2.500	2.500	2.500		
S	2.245	2.255		2.250	2.250	2.250	2.250		
T	1.120	1.130		1.125	1.125	1.125	1.125		
U	0.540	0.560		.550	.549	.549	.549		
V	0.793	0.803		.798	.798	.798	.798		
W	R.240	R.260		.250	.250	.250	.250		
X	0.040	0.060		.045	.045	.045	.045		
Y	0.100	0.120		.110	.110	.110	.110		
AA	R1.125	R1.145		1.132	1.133	1.132	1.132		
AB	R.490	R.510		.500	.500	.500	.500		
AC	0.615	0.635		.635	.635	.635	.635		
AD	0.240	0.260		.250	.249	.250	.250		
AE	1.810	1.830		1.817	1.818	1.818	1.817		
AF	0.240	0.260		.244	.245	.246	.245		
AG	0.140	0.160		.149	.149	.149	.149		
AH	0.140	0.160		.147	.147	.147	.147		
AI	0.140	0.160		.155	.155	.154	.154		
Accept/Reject									

Measured by:	mk	Audited by:	
Date:	11/10/10	Date:	11/10/10

Rev	Date	Change	Revised by	Approved
A	06.09.26	New Issue	KJ/EC	
B	08.10.07	Dimension H removed	KJ/DD	
C	08.11.28	Dimension 'M' revised	KJ/EC	
D	11.01.17	Note added to Dim I	KJ	AA



UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 73407  
C811108131